

GEARTECH	QUALITY PROCEDURE	No. QP6000	SHEET 1 OF 2	
		Rev. A		
Quality Assurance Plan		BY RLE	DATE	9/06/99
		CKD JRM	DATE	9/06/99
<div>1. Scope</div> <div>1.1 This procedure covers auditing and approving quality assurance (QA) plans.</div> <div>2. Referenced Documents</div> <div>2.1 AGMA/AWEA 921-A97 Recommended Practices for Design and Specification of Gearboxes for Wind Turbine Generator Systems.</div> <div>2.2 GEARTECH Specifications:</div> <div><div><div>CK1000</div><div>CK2000</div><div>CK3000</div><div>CK5000</div><div>CK6000</div><div>CK8000</div></div><div><div>QP1000</div><div>QP2000</div><div>QP3000</div><div>QP5000</div><div>QP6000</div><div>QP8000</div></div><div><div>Procurement process</div><div>Procurement specification</div><div>Bid solicitation and evaluation</div><div>Quality assessment</div><div>Quality assurance plan</div><div>Manufacturing audit</div></div></div> <div>3. Terminology</div> <div>3.1 Quality assurance plan- See QP5000.</div> <div>3.2 Hold point- Operation or procedure must be witnessed by purchaser's representative before moving component to next operation.</div> <div>3.3 Witness point- Operation or procedure may be witnessed by purchaser's representative if purchaser's representative is present during manufacture.</div> <div>3.4 Document required- Quality assurance must provide a certified copy of inspection or test report to purchaser's representative.</div> <div>4. Significance and Use</div> <div>4.1 QA Plan- AGMA/AWEA 921-A97, Annex D explains the procurement process including procurement specification, QA plan, quality control tests, quality documentation, and responsibilities of purchasers and gear manufacturers (see QP1000).</div> <div>4.2 Purpose- The QA plan specifies inspections and tests required to monitor the manufacturing process and gives acceptance criteria necessary to achieve quality goals of the procurement specification (see QP2000).</div> <div>4.3 Manufacturing audit- The QA plan informs manufacturer and purchaser of inspections and tests requiring hold points, witness points, and documentation.</div> <div>5. Procedure</div> <div>5.1 Responsibilities- The QA plan shall be designed and maintained by the gear manufacturer. The purchaser shall audit the QA plan to ensure that it is adequate to achieve quality goals. The purchaser's representative shall be responsible for witnessing inspections and tests defined by hold and witness points (see QP8000).</div> <div>5.2 Preliminary QA plan- During bid solicitation and evaluation, bidders may submit a preliminary QA plan in accordance with QP3000. However, the final QA plan shall be the responsibility of the gear manufacturer.</div>				

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<p>5.3 Final QA plan- During bid solicitation and evaluation, bidders shall propose a deadline for the final QA plan (see QP3000). The purchaser shall enforce the deadline.</p> <p>5.4 QA plan audit- The purchaser and gear specialist shall audit the QA plan for conformance to the procurement specification. See CK6000 for required content of QA plan. See QP3000 for a sample QA plan.</p> <p>5.5 QA plan approval- Manufacturing shall not begin until the purchaser approves the QA plan. See QP1000 for guidelines covering the procurement process.</p> <p>6. Acceptance Criteria</p> <p>6.1 Inspections and tests- The inspections and tests specified in the QA plan shall meet the requirements of the procurement specification.</p> <p>7. Report</p> <p>7.1 The purchaser shall write a report that includes recommendations for revisions to the QA plan required for conformance to the procurement specification.</p>				